












Work Order ID 55787

February 1, 2010 10:24:25 AM

Page 1

Item ID: D2892-1 Accept  Setup Start 
 Revision ID:  Stop 
 Item Name: Support
 Start Date: 2/02/10 Start Qty: 8.00  Cust Item ID:
 Required Date: 2/18/10 Req'd Qty: 8.00  Customer:
 Reference:

Approvals: Process Plan: PL Date: 10-2-01 Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2892	Rev A								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	0.00							
HAAS CNC vertical machine #1	Memo Machine as per Folio FA082 Tumble & Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								
120	QC8- Inspect parts - second check	0.00							
	QC	0.00							
Quality Control	Memo								

H.A 10/02/05

H.A 10/02/05
10.2.7

SF 10/02/04

7 1 Pro
2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2892-1 PAR #: _____ Fault Category: Machined Parts NCR: Yes No DQA: _____ Date: 10/05/00
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 10/05/00

NCR: 55787		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-2-7	100	• Drill fail in part RC. RPM too high operator error.	 B. B. 10.02.02 10/02/00	SCRAP + Don't replace Qty + 1	 B. B. 10.02.02 10/02/00	B. B. 10/02/00	 B. B. 10.02.02 10/05/00	10/05/20

NOTE: Date & initial all entries

Work Order ID 55787

February 1, 2010 10:24:25 AM



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Item ID: D2892-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 2/02/10 Start Qty: 8.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 	SprayPaint	0.00					10	05	17 (7)
	Spray Painting								
	Memo Prime grey per QSI005 110918 Paint Delfleet Blue B 113171 Clear Delfleet B 110899	0.00							
135 	QC14- Inspect Spray Paint	0.00				ST	10	05	19
	QC								
	Quality Control								
	Memo	0.00							
140 	QC3- Inspect Part Finish	0.00					10	05	19 (7)
	QC								
	Quality Control								
	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55787

February 1, 2010 10:24:25 AM



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Item ID: D2892-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 2/02/10 Start Qty: 8.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Identify as per dwg & Stock Location: *X-tube*

0.00



Packaging

Memo

0.00

Packaging

m/ 10 05 19 ⑦

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/05/19**MF 10-5-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 1, 2010 10:24:29 AM

Page 1
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Work Order ID: 55787



Parent Item: D2892-1



Parent Item Name: Support

Start Date: 2/02/10

Required Date: 2/18/10

Comments: IPP C 02.11.26 Added P/O KJ
IPP D 08.03.19 Re-format EC verified by: DD

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
DSK077		Manufactured	No			110	Each	11.0000	4.0000			

D2892-1 TURNING DETAIL

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	11	
43869	4	
53365	7	

4

H.A 10/02/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 53-787
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135		0.133	0.133	0.133	0.133	0.135
AB	0.290	0.310		0.310	0.310	0.310	0.310	0.310
AC	0.040	0.060		0.050	0.051	0.049	0.050	0.050
AD	0.115	0.135		0.125	0.125	0.125	0.125	0.125
AE	0.240	0.260		0.249	0.249	0.250	0.250	0.250
AF	0.188	0.193		0.189	0.189	0.189	0.189	0.188
AG	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AH	1.126	1.146		1.138	1.138	1.135	1.134	1.140
AI	0.454	0.474		0.465	0.465	0.463	0.464	0.464
AJ	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AK	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AL	0.257	0.262		0.258	0.258	0.258	0.258	0.257
AM	1.663	1.683		1.676	1.676	1.675	1.675	1.675
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AO	0.022	0.042		0.030	0.030	0.030	0.030	0.03
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: H A Date: 10/02/05

Audited by: S. P Date: 10/02/08

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 55-787
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892	Rev: A	Page 2 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#6	#7	#8	#	#
HAAS Section								
AA	0.115	0.135		.135	.135			
AB	0.290	0.310		.310	.310			
AC	0.040	0.060		.050	.050			
AD	0.115	0.135		.125	.125			
AE	0.240	0.260		.250	.250			
AF	0.188	0.193		.189	.188			
AG	0.240	0.260		.250	.250			
AH	1.126	1.146		1.140	1.140			
AI	0.454	0.474		.464	.464			
AJ	0.240	0.260		.250	.250			
AK	0.053	0.073		.063	.063			
AL	0.257	0.262		.257	.257			
AM	1.663	1.683		1.675	1.675			
AN	0.053	0.073		.063	.063			
AO	0.022	0.042		.032	.032			
AP	2.779	2.789		2.784	2.784			
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: *[Signature]* **Date:** 10-2-7

Audited by: *[Signature]* **Date:** 10/02/04

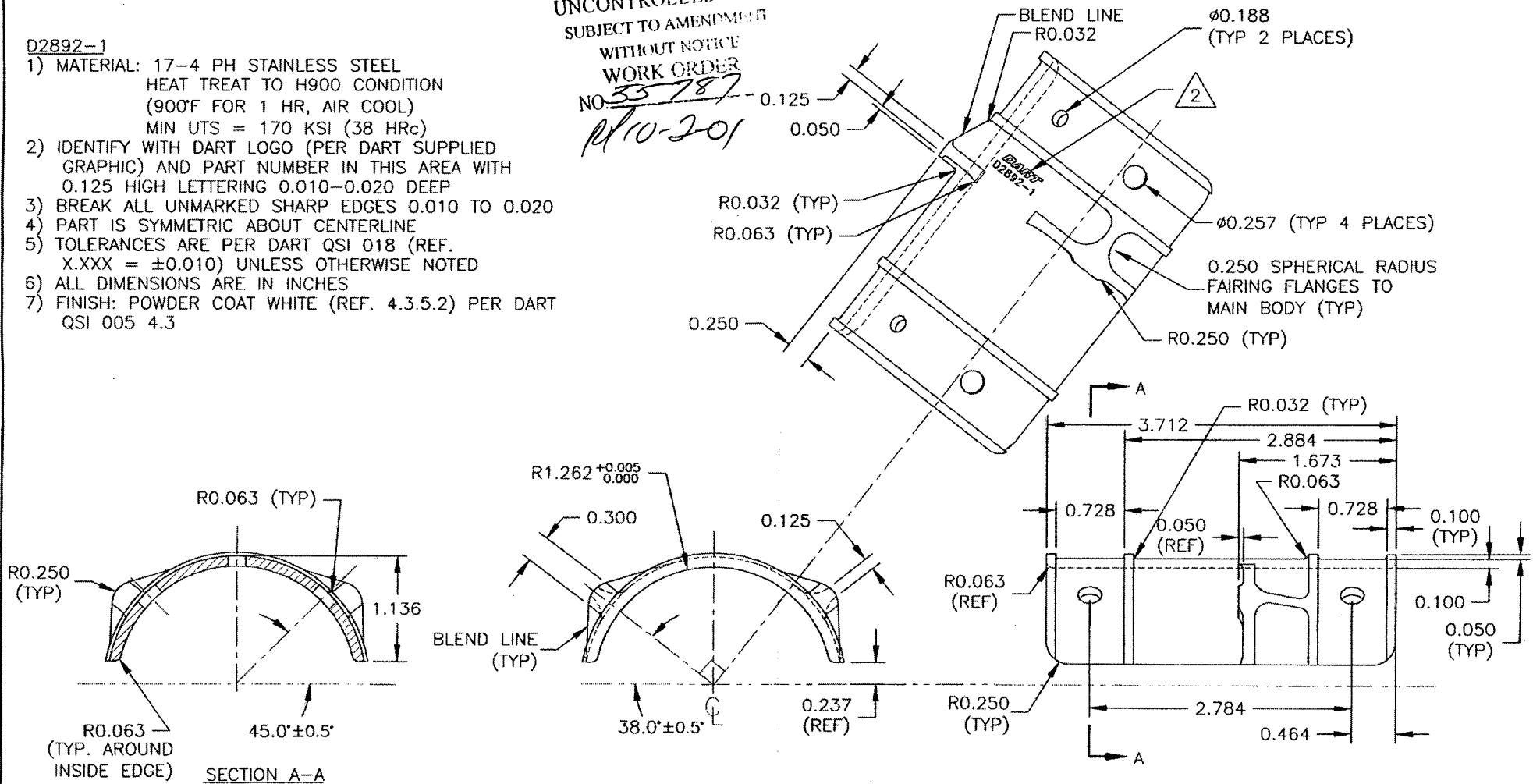
Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35787
10-201

D2892-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



A		00.11.17	NEW ISSUE
DESIGN	CP	DRAWN BY	CP
CHECKED	#	APPROVED	#
DATE	00.11.17	TITLE	02.500 SUPPORT
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